

# Work Order ID 58094

Thursday, April 22, 2010 3:18:08 PM



Page 1

Item ID: D3912-3-

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Block

Stop



Start Date: 4/23/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 4/30/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-4-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3912

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 2.50" LONG

G.A 10/04/29

12 4

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA870 AND DWG

FOLIO REV: A

DWG REV: A

DEBURR

mmj 10/04/29

10/05/01

12 4

PTO

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3912-3 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: Yes No DQA: Yes No Date: 10/05/03  
Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/05/06

NCR: <u>58094</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/05/01</u>	<u>110</u>	<u>Wrong info in the folio</u> <u>↳ Use center drill #2 instead of #4</u> <u>↳ the #4 center drill opened</u> <u>the <math>\phi.129</math>" hole to <math>\phi.137</math>"</u> <u>↳ 0.003" over tolerance x4 parts</u>	<u>[Signature]</u>	<u>Change #4 center drill for</u> <u>a #2 center drill.</u> <u>↳ update folio info for the</u> <u>correct center drill.</u>	<u>10/05/01</u> <u>[Signature]</u>	<u>26</u> <u>10/05/03</u>	<u>[Signature]</u>	<u>10/05/03</u>
<u>10/05/01</u>	<u>110</u>	<u>0.500 <math>\pm</math> 0.010 dim is</u> <u>0.485 X 3 parts</u> <u>ec. folio.</u>	<u>[Signature]</u>	<u>Scrap destroyed &amp; replace</u>				

NOTE: Date & initial all entries

**Work Order ID 58094**

Thursday, April 22, 2010 3:18:08 PM

Page 2

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Item Name: Eyebolt Block

Start Date: 4/23/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 4/30/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

mmv  
10/04/29  
ISA 10/05/01

12 4

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M.A 10/04/05

12 0

160

Identify as per dwg &amp; Stock Location: 96

0.00



Packaging

Memo

0.00

Packaging

10-5-5

(120) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58094**

Thursday, April 22, 2010 3:18:08 PM



Page 3

Item ID: D3912-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Block

Start Date: 4/23/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 4/30/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

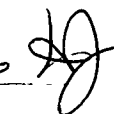


QC

Memo

0.00

Quality Control

10/05/06   
CL101515

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, April 22, 2010 3:18:08 PM

Page 1

Work Order ID: 58094



Parent Item: D3912-3



Parent Item Name: Eyebolt Block

Start Date: 4/23/2010

Required Date: 4/30/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303B1.000X1.000  303 BAR 1" X 1"		Purchased	No			100	f	12.0000	2.6274			

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT53

12

113341

12

M113719



~~12~~

2.6274<sup>ft</sup> H.A 10/04/29  
+  
0.8758<sup>ft</sup> DIA 10/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

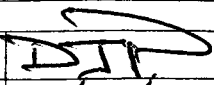


DART AEROSPACE LTD		Work Order: 58094
Description: EYEBOH Block		Part Number: D3912-3
Inspection Dwg: 3912	Rev: A	Page 1 of 1

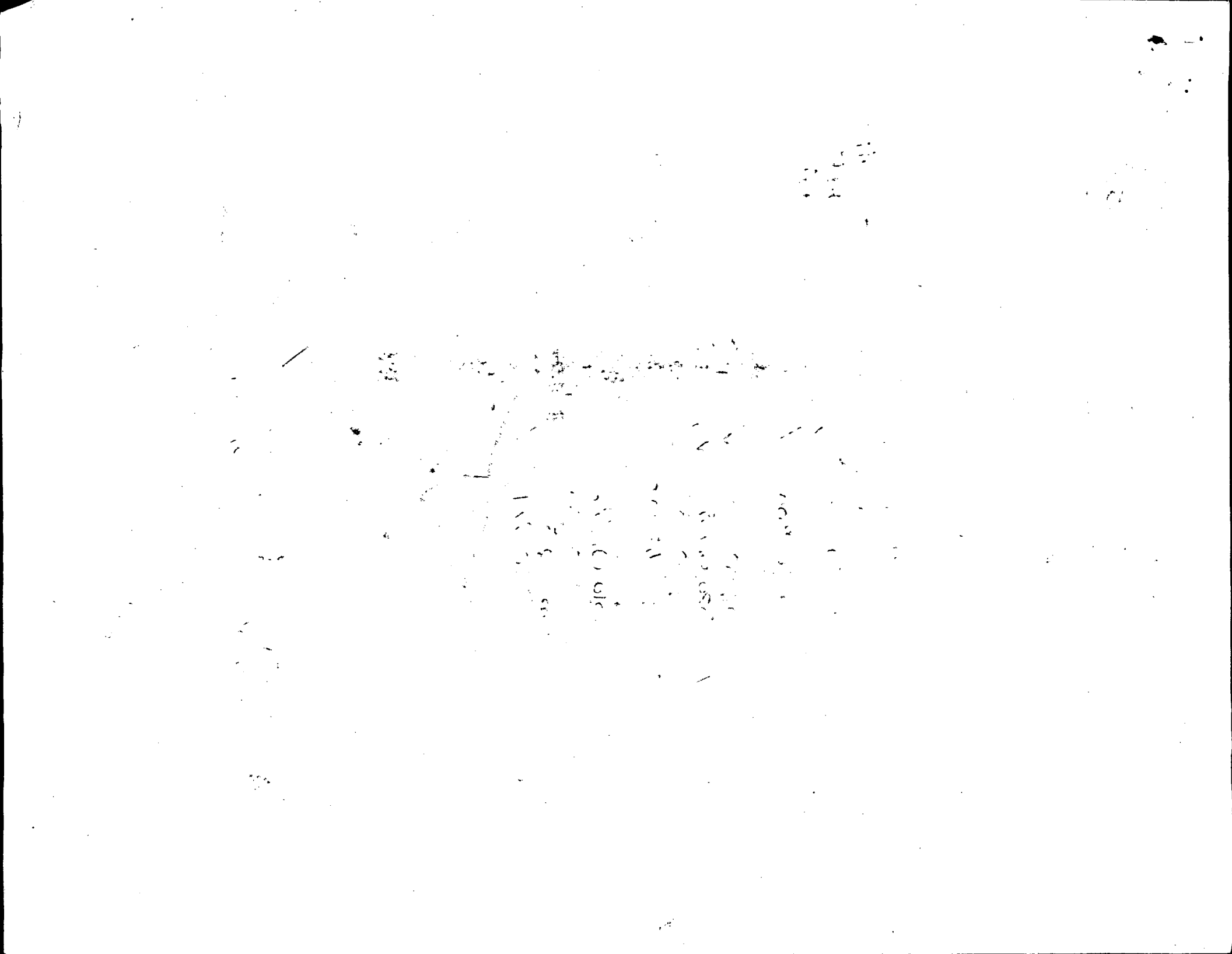
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.30	$\pm 0.030$	2.310	✓			
$\phi 0.129$	$+0.005/-0.001$	0.130	✓			Thru 4PL
0.50	$\pm 0.030$	0.500	✓			REF
R0.13	$\pm 0.030$	0.130	✓			TYP
0.500	$\pm 0.010$	0.491	✓			
R0.125	$\pm 0.010$	0.125	✓			
0.63	$\pm 0.030$	0.625	✓			
0.750	$+0.000/-0.020$	0.739	✓			
0.38	$\pm 0.030$	0.38	✓			
1.500	$\pm 0.010$	1.500	✓			0.500" Pitch
0.800	$+0.000/-0.010$	0.796	✓			
0.400	$\pm 0.010$	0.400	✓			
0.516	$+0.015/-0.000$	0.516	✓			
1.00	$\pm 0.030$	0.994	✓			

Measured by: 	Audited by: G.A	Prototype Approval:	N/A
Date: 10/05/01	Date: 10/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



Technical drawing of a plate with a grid of holes and a slanted hole. The drawing includes dimensions for hole positions, sizes, and plate thickness. A side view shows the plate's profile with a 2.00 inch height.

Key dimensions and features:

- Overall width: 3.15
- Horizontal hole spacing: 1.500 (0.500 PITCH)
- Vertical hole spacing: 1.500 (+0.020, -0.000)
- Top hole offset: 0.38
- Top hole radius: R0.13 TYP
- Slanted hole radius: 0.375
- Slanted hole vertical offset: 0.517
- Slanted hole vertical spacing: 1.000
- Slanted hole angle: 105° REF
- Bottom hole radius: 0.129 (8 PL)
- Bottom hole radius: 0.257 (2 PL)
- Bottom hole horizontal offset: 3.65
- Bottom hole horizontal offset: 3.69 REF
- Side view height: 2.00
- Side view bottom offset: 0.125 REF

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: ID AT ASSEMBLY  
7) WEIGHT -3: 0.30 lbs  
              -5: 0.24 lbs

RELEASED  
2010-03-12  
WMP

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3912</b>  TITLE <b>EYEBOLT RECEIVER ASSY</b>  COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART OF THIS DOCUMENTATION THAT IT IS AND NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A
DRAWN	JPH		SHEET 3 OF 3
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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